

C6225332

MODEL 700™ M24

Model **700 M24™**

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

BARBER - M24 ~~0042989~~ **M2400013028**

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225332*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	<i>2/1</i>	<i>FB</i>
600	PROOF	<i>2/9/88</i>	<i>RW</i>
615	MAGNAFLUX BARREL	<i>2/18/88</i>	<i>P/C</i>
	MAGNAFLUX BOLT	<i>2/25/88</i>	<i>P/C</i>
620	COATING	<i>3/21/88</i>	<i>TJA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/9/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/9/88	RW
	C) Inspect Ejector Hole for Chamfer		9/9/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/9/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		9 Sept 88	RW JS
	F) Safety on Force	6 6 6	9 Sept 88	RW JS
	G) Safety off Force	5 3.5 3.5	9 Sept 88	RW JS
	H) Trigger Pull Test & Retainability		9 Sept 88	RW JS
	I) Firing Pin Indent	0.022 0.022 0.025	9 Sept 88	RW JS
	J) Assemble Stock		9/15/88	RW
	K) Assemble Swivel Studs		10-12-88	JS
	L) Attach Front & Rear Sight Assemblies		9/15/88	RW
	M) Iron Sight Alignment		9/15/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/15/88	RW
	O) Attach Scope to Rifle		10/5/88	RW
	P) Detach & Attach Scope 20 times		10-5-88	JS
640	Gallery Target & Test	85 R 70L	10/11/88	W.B.
	A) Optical Clarity of Scope		10/11/88	W.B.
645	Inspect for Live Ammo		10/11/88	W.B. AC
655	Final Inspection			
	A) Headspace		10-12-88	JS
	B) Trigger Pull		10-14-88	JS
	C) Function		10-12-88	JS
660	Pack		10-21-88	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225332

DATE 9 Sept 88

TESTER J. H. + G. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.69	2.56	2.73	2.74	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.67	2.52	2.72	2.74	
PULL #3	2.62	2.49	2.70	2.92	
PULL #4	2.61	2.50	2.73	2.68	
PULL #5	2.58	2.50	2.70	2.60	
TOTAL	13.17	12.57	13.58	13.68	
AVG.	2.634	2.514	2.716	2.736	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.44		
PULL #2	3.40	3.50		
PULL #3	3.42	3.49		
PULL #4	3.45	3.48		
PULL #5	3.45	3.49		
TOTAL	17.09	17.40		
AVG.	3.418	3.48		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.17		4.11
PULL #2	4.26	4.29		4.13
PULL #3	4.23	4.31		4.13
PULL #4	4.29	4.28		4.01
PULL #5	4.28	4.31		4.13
TOTAL	21.33	21.26		20.51
AVG.	4.266	4.252		4.102

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225332

CENTROIDAL DISTANCES

0 TO	1	.631596
1 TO	2	.44893
1 TO	3	1.4136
1 TO	4	.482954
1 TO	5	.503668

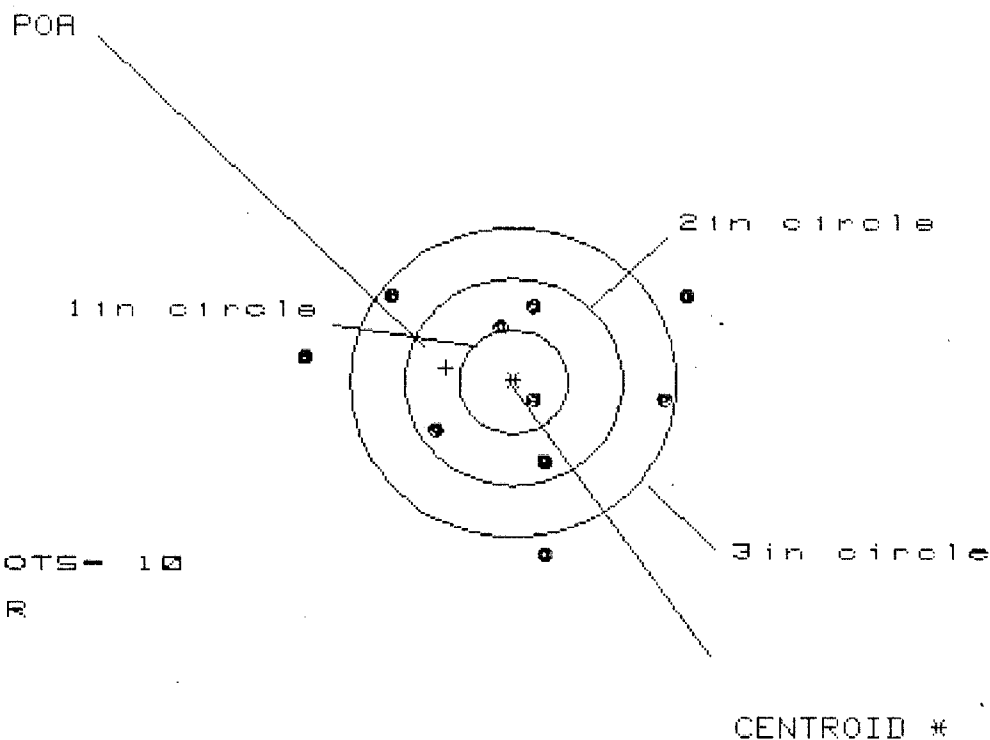
+ 1 2 <-----POA
3
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .9858
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.5568
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.13218
THE AMR FOR THIS RIFLE IS: .9246

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225332

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.493

VS= 2.570

GS= 3.546

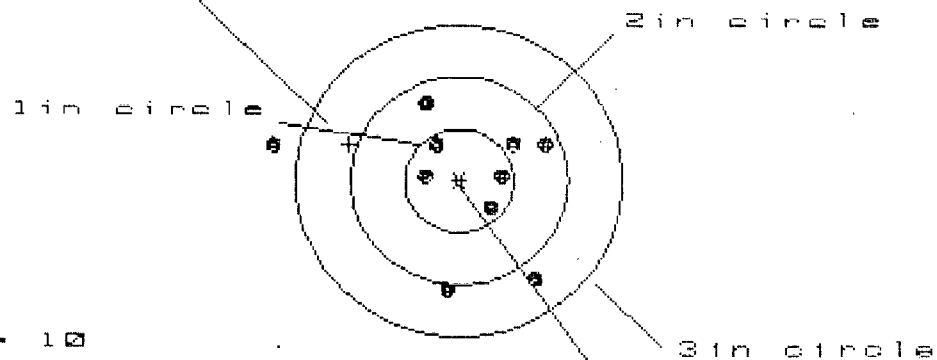
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.556	1.341	1.311
MINIMUM X	-1.937	-1.305	-1.137
MAXIMUM Y	.873	.902	.957
MINIMUM Y	-1.697	-1.668	-1.555
CENTROID X	.617	.832	.664
CENTROID Y	-.135	-.164	-.277
POR TO CENTROID in.	.631	.848	.720
MIN RADIUS	.208	.115	.114
MEAN RADIUS	1.146	1.042	.956
MAX RADIUS	1.954	1.672	1.581
HORIZONTAL SPREAD	3.493	2.646	2.448
VERTICAL SPREAD	2.570	2.570	2.512
EXTREME SPREAD	3.546	2.886	2.886
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225332

CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 9

HS = 2.503

VS = 1.779

GS = 2.695

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.818	.630	.694
MINIMUM X	:	-1.685	-.526	-.462
MAXIMUM Y	:	.724	.759	.645
MINIMUM Y	:	-1.055	-1.020	-1.133
CENTROID X	:	1.010	1.198	1.134
CENTROID Y	:	-.352	-.387	-.274
POA TO CENTROID in.	:	1.070	1.259	1.166
MIN RADIUS	:	.313	.199	.248
MEAN RADIUS	:	.765	.630	.566
MAX RADIUS	:	1.715	1.071	1.163
HORIZONTAL SPREAD	:	2.503	1.156	1.156
VERTICAL SPREAD	:	1.779	1.779	1.779
EXTREME SPREAD	:	2.695	1.962	1.790
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225332

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.371

VS= 2.454

GS= 2.899

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.211	1.082	1.113
MINIMUM X	-1.160	-1.083	-1.051
MAXIMUM Y	1.301	1.172	1.289
MINIMUM Y	-1.153	-.836	-.689
CENTROID X	1.511	1.640	1.609
CENTROID Y	-1.230	-1.101	-1.248
POA TO CENTROID in.	1.948	1.976	2.036
MIN RADIUS	.043	.199	.141
MEAN RADIUS	.902	.836	.755
MAX RADIUS	1.636	1.200	1.298
HORIZONTAL SPREAD	2.371	2.165	2.165
VERTICAL SPREAD	2.454	2.008	1.978
EXTREME SPREAD	2.899	2.168	2.168
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

12 Oct 1988

FILE: \PATTERNING\CENTERFIRE_PATT\06225332

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 1.912

VS = 2.834

GS = 3.000

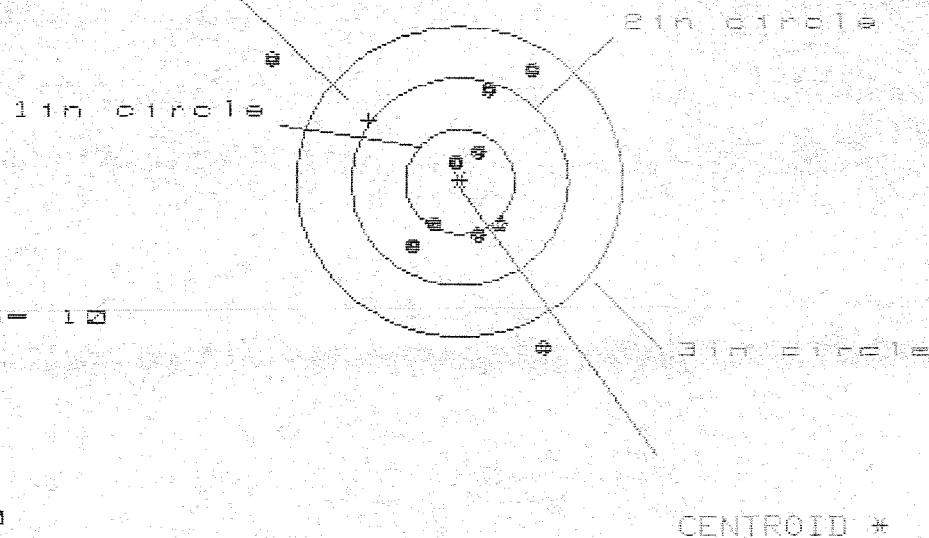
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	1.130	1.057
MINIMUM X	:	-.822	-.782	-.855
MAXIMUM Y	:	1.594	1.268	1.135
MINIMUM Y	:	-1.240	-1.063	-.698
CENTROID X	:	.958	.918	.991
CENTROID Y	:	-.477	-.654	-.521
POA TO CENTROID in.	:	1.070	1.127	1.120
MIN RADIUS	:	.398	.373	.426
MEAN RADIUS	:	.914	.807	.759
MAX RADIUS	:	1.634	1.341	1.210
HORIZONTAL SPREAD	:	1.912	1.912	1.912
VERTICAL SPREAD	:	2.834	2.331	1.833
EXTREME SPREAD	:	3.000	2.477	2.249
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/G8225332

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 8

HS = 2.510

VS = 2.863

GS = 3.807

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.800	.610	.574
MINIMUM X	:	-1.710	-.618	-.542
MAXIMUM Y	:	1.215	1.175	.986
MINIMUM Y	:	-1.648	-1.513	-.682
CENTROID X	:	.833	1.023	.947
CENTROID Y	:	-.590	-.725	-.536
POA TO CENTROID in.	:	1.021	1.254	1.088
MIN RADIUS	:	.186	.298	.204
MEAN RADIUS	:	.896	.755	.626
MAX RADIUS	:	2.098	1.631	1.141
HORIZONTAL SPREAD	:	2.510	1.228	1.116
VERTICAL SPREAD	:	2.863	2.688	1.668
EXTREME SPREAD	:	3.807	2.690	2.007
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	